

Work Order ID 158186

Monday, March 13, 2017 12:57:01 PM

158186

Page 1

Item ID: D4882-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut

Start Date: 3/20/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/24/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

MAR 13 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4882

C

100

0.05

100

Doosan

DOOSAN LATHE

Memo

0.87

Doosan Lathe

1- Turn as per Folio FB247

Rev: NA & Dwg D4878 Rev: C

2- Deburr

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

Quality Control

6 _____ P17-03-20

6 _____ P17-03-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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NR2

[illegible]

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																						OTHER : _____																																									

Monday, March 13, 2017 12:57:01 PM

Page 3

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									DAS 38 9-89
QC	Memo	0.02							
Quality Control									MAR 27 2017
160	Identify as per dwg & Stock Location: <u>5183</u>	0.00							
160									MAR 27 2017
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									17/3/30 JF
QC	Memo	0.10							
Quality Control									DAS 21 9-89 MAR 29 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 158186

158186

Parent Item: D4882-1

D4882-1

Parent Item Name: Strut

Start Date: 3/20/2017

Required Date: 3/24/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.750		Purchased	No			100	f	9.0800	0.409	2.583158			

M174PH-H900R0 750

17-4 SS H900 ROUND BAR 0.750"

Location

Loc Qty

Loc Code

MAT030

9.08

m136481

9.08

4.039 3-17-03-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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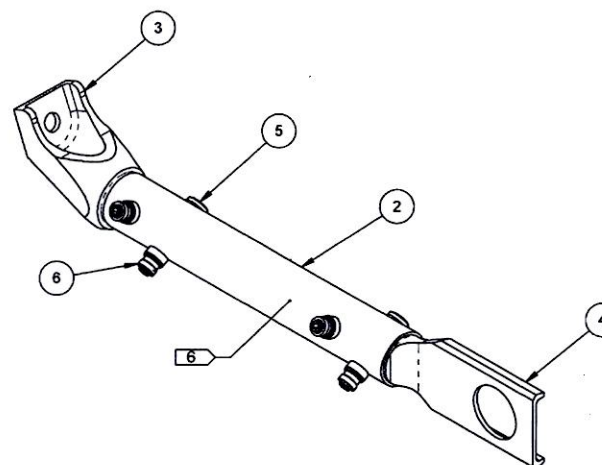
FIRST ARTICLE INSPECTION CHECKLIST

DAS

44
9.80

y 18

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4882-041	LEG ASSEMBLY, LH
2	1	D4882-1	STRUT
3	1	D4883-3	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4882-041 LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-102-013)

NOTES:

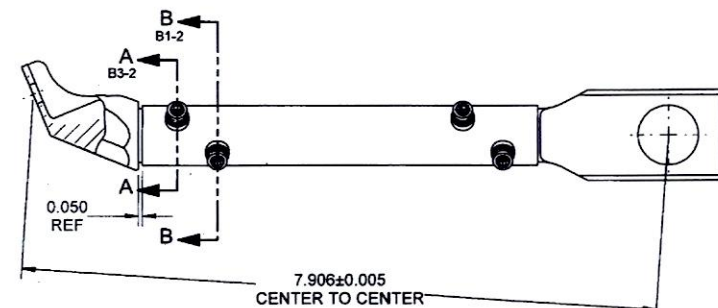
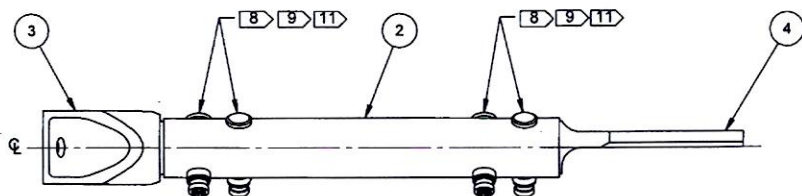
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.57 lbs
- 8) ALIGN PILOT HOLES IN D4882-1 WITH PILOT HOLES IN D4883-3 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9975
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9975
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158786

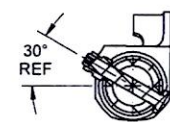
MAR 13 2017

RELEASED
2014-07-07

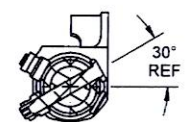
C	HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 8) (ZN A8-5), ADD LHRH (ZN B4-1, B4-2, B4-3, B4-4)	RF	14.06.24
B	REVISE NOTES 6), 7) & 9) (ZN A8-1); REVISE SECTIONS A-A, B-B (ZN B2-2, B3-2); ADDED -042 (ZN B4-3, A4-4); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4882	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4882-041 LEG ASSEMBLY, LH
AUXILIARY VIEW



SECTION A-A C7-2
2 PL

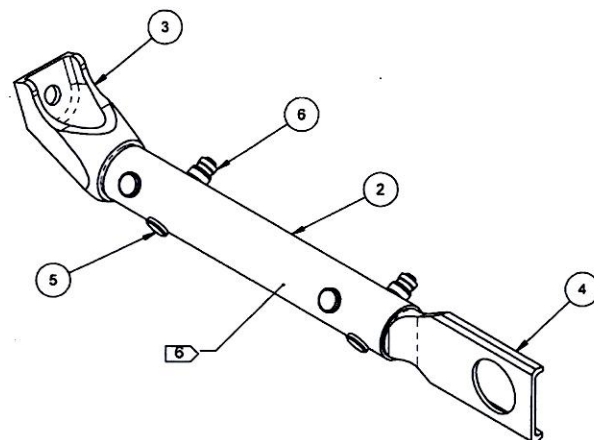


SECTION B-B C7-2
2 PL

RELEASED
2014-07-07
mc

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO. D4882	REV. C
	MFG. APPR.	JFS	SHEET 2 OF 5	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4882-042	LEG ASSEMBLY, RH
2	1	D4882-1	STRUT
3	1	D4883-3	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4882-042 LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 206-062-102-013)

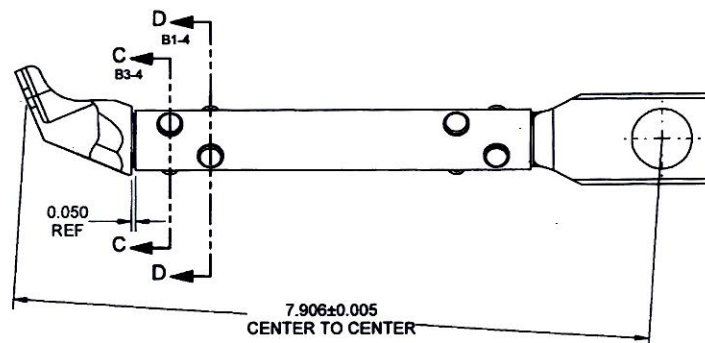
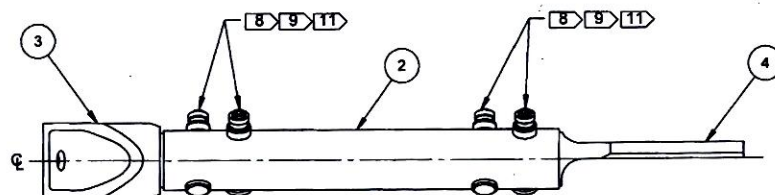
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.57 lbs
- 8) ALIGN PILOT HOLES IN D4882-1 WITH PILOT HOLES IN D4883-3 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9975
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9975
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

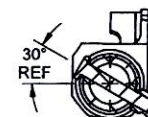
APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4882	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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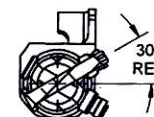
RELEASED
2014-07-07



D4882-042 LEG ASSEMBLY. RH
AUXILIARY VIEW



SECTION C-C C7-4
2 PL



SECTION D-D C7-4
2 PL

RELEASED
2014-07-07

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4882	SHEET 4 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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RELEASED
2014-07-07
100

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
7) WEIGHT: 0.15 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LE

APPROVED	DESIGN	RF	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	HS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4882	SHEET 5 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35666**

Purchase Order Date 3/22/2017

PO Print Date 3/24/2017

Page Number 1 of 3

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone

Ship Via: Delivered
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
----------	------------------------------	---------------------	-------------------	----	--------------------------	---------------	----------------

1	71401-45	procurement quality clauses	3/24/2017		1.00	\$0.00	\$0.00
			No				
			3/24/2017				
		Procurement Quality Clauses					
		A005 right of entry					
		A012 chemical and physical test report					
		A016 personnel qualification					
		A017 raw material identification (as applicable)					
		A024 process certifications					
		A026 certification of material conformance					
		A041 quality management system					
		A042 dart notification by supplier					
		A043 retention of quality documents					

Line Total: \$0.00

2	158186	D4882-1 STRUT	3/24/2017		6.00	\$0.00	\$0.00
			Yes				
			3/24/2017				

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

DAS
38
9-89

SEP 17-03-24

Note:

3/24/2017

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO31514	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO35666
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 3 CROSSTUBES AND 10 STRUTS AS PER PO35666

3 STAINLESS STEEL AFT CROSSTUBES , ITEM ID# D412-664-403 , WORK ORDERS ID# 157955, 157956, 157957

4 STRUTS , ITEM ID# D4880-1 , WORK ORDER ID# 158185

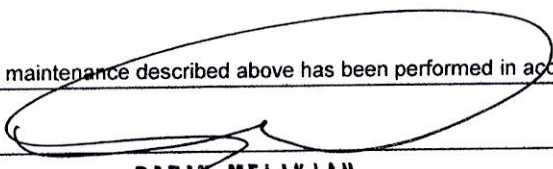
6 STRUTS , ITEM ID# D4882-1 , WORK ORDER ID# 158186

SP/7 DB 24

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , EMU. MPO15896, DEV. MPO11715 , UV LIGHT M-20142						MAR 24 2017	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

DAS
38
9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: MAR 24 2017
Name: RAFIK MELIKIAN		